

§ 56.90–5 Bolting procedure.

(a) All flanged joints shall be fitted up so that the gasket contact faces bear uniformly on the gasket and then shall be made up with relatively uniform bolt stress. Bolt loading and gasket compression need only be verified by touch and visual observation.

(b) (Reproduces 135.2.2.) In bolting gasketed flanged joints, the gasket shall be properly compressed in accordance with the design principles applicable to the type of gasket used.

(c) Steel to cast iron flanged joints shall be assembled with care to prevent damage to the cast iron flange in accordance with § 56.25–10.

(d) (Reproduces 135.2.4.) All bolts shall be engaged so that there is visible evidence of complete threading through the nut or threaded attachment.

§ 56.90–10 Threaded piping (reproduces 135.4).

(a) Any compound or lubricant used in threaded joints shall be suitable for the service conditions and shall not react unfavorably with either the service fluid or the piping materials.

(b) Threaded joints which are to be seal welded shall be made up without any thread compound.

(c) Backing off to permit alignment of pipe threaded joints shall not be permitted.

Subpart 56.95—Inspection**§ 56.95–1 General (replaces 136).**

(a) The provisions in this subpart shall apply to inspection in lieu of 136 of ANSI-B31.1.

(b) Prior to initial operation, a piping installation shall be inspected to the extent necessary to assure compliance with the engineering design, and with the material, fabrication, assembly and test requirements of ANSI-B31.1, as modified by this subchapter. This inspection is the responsibility of the owner and may be performed by employees of the owner or of an engineering organization employed by the

owner, together with the marine inspector.

[CGFR 68–82, 33 FR 18843, Dec. 18, 1968, as amended by CGFR 69–127, 35 FR 9979, June 17, 1970]

§ 56.95–5 Rights of access of marine inspectors.

Marine inspectors shall have rights of access to any place where work concerned with the piping is being performed. This includes manufacture, fabrication, assembly, erection, and testing of the piping or system components. Marine inspectors shall have access to review all certifications or records pertaining to the inspection requirements of § 56.95–1, including certified qualifications for welders, welding operators, and welding procedures.

§ 56.95–10 Type and extent of examination required.

(a) *General.* The types and extent of nondestructive examinations required for piping must be in accordance with this section and Table 136.4 of ANSI-B31.1. In addition, a visual examination shall be made.

(1) 100 percent radiography¹ is required for all Class I, I-L, and II-L piping with wall thickness equal to or greater than 10 mm (.375 in.).

(2) Nondestructive examination is required for all Class II piping equal to or greater than 18 inches nominal diameter regardless of wall thickness. Any test method acceptable to the Officer in Charge, Marine Inspection may be used.

(3) Appropriate nondestructive examinations of other piping systems are required only when deemed necessary by the Officer in Charge, Marine Inspection. In such cases a method of testing satisfactory to the Officer in Charge, Marine Inspection must be selected from those described in this section.

(b) *Visual examination.* Visual examination consists of observation by the marine inspector of whatever portions of a component or weld are exposed to such observation, either before, during, or after manufacture, fabrication, assembly or test. All welds, pipe and piping components shall be capable of complying with the limitations on imperfections specified in the product